

I claim:

1. A method of securely mounting gemstones into an effectively invisible jewelry setting, comprising:
  - producing a wax model of the jewelry setting;
  - placing a plurality of gemstones in said wax model;
  - adding a wax flange for securing the gemstones to the wax model, wherein said flange is placed between said gemstones;
  - forming a mold from the wax model;
  - removing the wax model from the mold, thereby forming a mold cavity; and
  - filling the mold cavity with molten metal to produce a jewelry setting having a metal flange for securing the gemstones substantially but not entirely concealed within the setting beneath the gemstones.
2. The method of claim 1, wherein said flange includes a base, a head located at the top of said base, and a narrow portion between said head and said base, wherein, upon being placed between said gemstones, the bottom of said base is in contact with the floor of the setting, said base is concealed by the gemstones, and the girdle of said gemstones fit into the narrow portion of the flange.
3. The method of claim 3, wherein the upper surfaces of said head are sloped to form a ridge.
4. The method of claim 3, further comprising coating the two upper surfaces of the head of the metal flange with a reflective metal.

5. The method of claim 4, wherein said reflective metal is white gold, platinum, iridium, rhodium or an alloy comprising one or more of these metals.

6. The method of claim 1, wherein said flange, parallel walls and floor are curved to form a wax model of a curved channel setting enclosure.

7. A method for producing an effectively invisible jewelry setting for gemstones, comprising,

producing a wax model of the jewelry setting with at least two parallel walls and a floor, said at least two parallel walls having a groove along their opposing interior surfaces, and said floor having a slot positioned between said two parallel walls;

placing a series of gemstones in the wax model of the setting to produce a first and second row of gemstones;

inserting a flange between the first and second rows of gemstones and into said depression on the floor of the wax model, said flange extending to a height above the floor of the wax model to a level above the plane of the girdles of said rows of gemstones;

forming a mold from the wax model;

removing the wax from the mold; and

filling the mold with a molten metal to produce an effectively invisible jewelry setting.

8. The method of claim 7, wherein said flange includes a base, a head located at the top of said base, and a first and second rabbet located on opposite sides of the flange and between said base and said head, wherein, upon being placed between said gemstones, the

bottom of said base is in contact with the floor of the setting, said base is concealed by the gemstones, and the girdles of said gemstones fit into the rabbets of the flange.

9. The method of claim 8, wherein the upper surfaces of said head are sloped together to form a ridge.

10. The method of claim 9, further comprising the step coating the head of the flange in the effectively invisible setting with a reflective metal, thereby concealing the head of the flange.

11. The method of claim 10, wherein said reflective metal is white gold, platinum, iridium, rhodium or an alloy comprising one or more of these metals.

12. A method for producing an effectively invisible channel setting, comprising,  
producing a wax model of the jewelry setting including at least two parallel walls  
integrally formed with and at right angles to a floor, said at least two  
parallel walls having a first and second groove along their opposing  
interior surfaces, and said floor having an aperture between said two  
parallel walls;  
placing gemstones in the wax model of the setting in a first and a second row of  
gemstones;  
inserting a flange between the first and the second row of gemstones and into said  
aperture on the floor of the wax model, said flange including a head, a  
base, and a narrow portion for engaging the girdles of the first and second  
rows of gemstones;  
casting an investment mold around the wax model;  
removing the wax model from the mold; and

filling the mold with a molten metal, thereby forming an effectively invisible setting for the gemstones.

13. The method of claim 12, wherein upon being placed between said gemstones, the base of said flange is concealed by the gemstones, and the head of said flange is above the plane of the girdle of the gemstones.

14. The method of claim 12, wherein the sides of the head of said flange are sloped to form a ridge.

15. The method of claim 12 further comprises the step of coating the top of the head of the flange in the effectively invisible setting with a reflective metal.

16. The method of claim 15, wherein said reflective metal is white gold, platinum, iridium, rhodium or an alloy comprising one or more of these metals.

17. The method of claim 12, wherein said parallel walls and floor form a wax model of a curved channel setting.

18. The method of claim 12, wherein said parallel walls and floor form a wax model of a square channel setting.